

Wednesday, May 02, 2012 1:04:19 PM

Page 1

Quality Control

12 Ø JM
12-6-6

12 ~~0~~ Jm
 12-6-6

12

12' 06' 07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84070

Wednesday, May 02, 2012 1:04:20 PM

84070

Page 2

Item ID: D2144

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Hinge Bracket

Start Date: 5/2/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 5/8/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Small Fab	Small Fab	0.00							
Small Fab	Memo Debur if necessary	0.00							
140 *140* Brake NC	NC BRAKE	0.00				12			8/12/06/23
Brake NC	Memo Form as per Dwg D2144Rev: 1	0.00							
150 *150* QC	QC5- Inspect part completeness to step on W/O	0.00				412			
Quality Control	Memo	0.00							

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84070

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N900040100

NS1

Stop *NS2*

12

12

Customer:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

160

Large Fab


1- Weld corner as per Dwg D2144 & QSI 0042- Grind flush

② 12-07-18

170

0.00

Quality Control

82 12-7-18 

180

Memo

Quality Control

DAS
16
0-6

W/O:		WORK ORDER CHANGES					
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Work Order ID 84070

Wednesday, May 02, 2012 1:04:20 PM

84070

Page 4

Item ID: D2144 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Hinge Bracket
 Start Date: 5/2/2012 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 5/8/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* Powdercoat Powder Coating <i>m121841</i>	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: <i>7:30</i> FINISH TIME: <i>8:00</i>	0.00 0.00				<i>12X</i>	<i>0</i>		<i>MT</i> <i>12/07/19</i>
200 *200* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>12</i>	<i>0</i>		<i>BR 12-7-19</i>
210 *210* Packaging Packaging	Identify as per dwg & Stock Location: <i>876</i> Memo	0.00 0.00				<i>12x</i>			<i>SP</i> <i>12-7-19.</i>

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 84070

Wednesday, May 02, 2012 1:04:20 PM

84070

Page 5

Item ID: D2144 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Hinge Bracket
Start Date: 5/2/2012 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 5/8/2012 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.00							
Quality Control									

12/7/20 JG

MF
12-07-19

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Wednesday, May 02, 2012 1:04:24 PM

Page 1

Work Order ID: 84070

84070

Parent Item: D2144

D2144

Parent Item Name: Hinge Bracket

Start Date: 5/2/2012

Required Date: 5/8/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: D04.05.06ReformatKJ/RF
IPP Rev:E Now on Waterjet 06-10-15 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			120	sf	94.3720	0.0945	1.134			
**													

M304S16GA

304/316 Sheet .063

Location	Loc Qty	Loc Code
MAT020	94.372	
120866	14.246	
120877	80.126	

121626

121626

JM
12-6-6

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DART AEROSPACE LTD		Work Order:	841070
Description: Hinge Bracket		Part Number:	D2144
Inspection Dwg: D2144 Rev: D		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.381	+/-0.010	3.387"	✓		✓	mmoi
3.022	+/-0.010	3.022"	✓		✓	
2.468	+/-0.010	2.468"	✓		✓	
1.913	+/-0.010	1.915"	✓		✓	
1.555	+/-0.010	1.557"	✓		✓	
4.126	+/-0.010	4.131"	✓		✓	
3.465	+/-0.010	3.462"	✓		✓	
0.340	+/-0.010	0.343"	✓		✓	
0.625	+/-0.010	0.625"	✓		✓	
1.000	+/-0.010	0.002"	✓		✓	
1.083	+/-0.010	1.084"	✓		✓	
1.660	+/-0.010	1.668"	✓		✓	
2.312	+/-0.010	2.314"	✓		✓	
2.844	+/-0.010	2.843"	✓		✓	
3.294	+/-0.010	3.293"	✓		✓	
Ø0.257	+0.006/-0.001	0.257"	✓		✓	
Ø0.171	+0.005/-0.001	0.171"	✓		✓	
Ø0.320	+0.006/-0.001	0.320"	✓		✓	
0.354	+/-0.010	0.359"	✓		✓	
0.063	+/-0.010	0.057"	✓		✓	

Measured by:	Jm	Audited by:	W/W	Prototype Approval:	N/A
Date:	12-06-07	Date:	12-06-07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.31	New Issue	KJ/JLM	

W/O:		WORK ORDER CHANGES					
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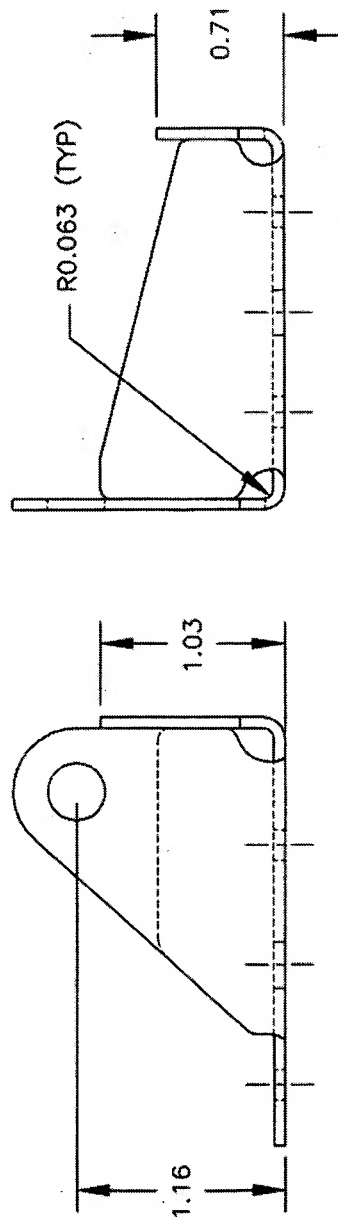
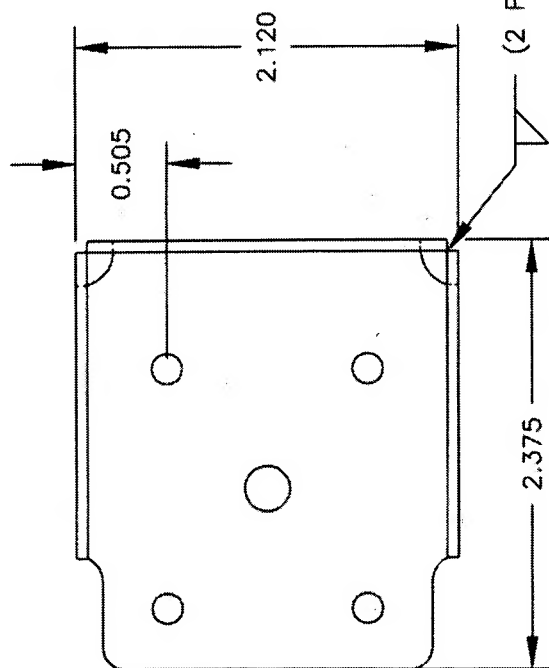
NOTE: Date & initial all entries



RELEASED
98.10.15 KE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 24022

11/2-05-20



FINISH: POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
WELD PER DART QSI 004

DESIGN BW	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED MA	APPROVED CA	DRAWING NO. D2144	REV. D SHEET 1 OF 2
DATE 98.10.08		TITLE HINGE BRACKET	SCALE 1:1
A	95.03.17	NEW ISSUE	
C	96.06.05	FLAT PATTERN LAYOUT ADDED	
D	98.10.08	UPDATED DIMS AFTER BEND (TSR A917)	

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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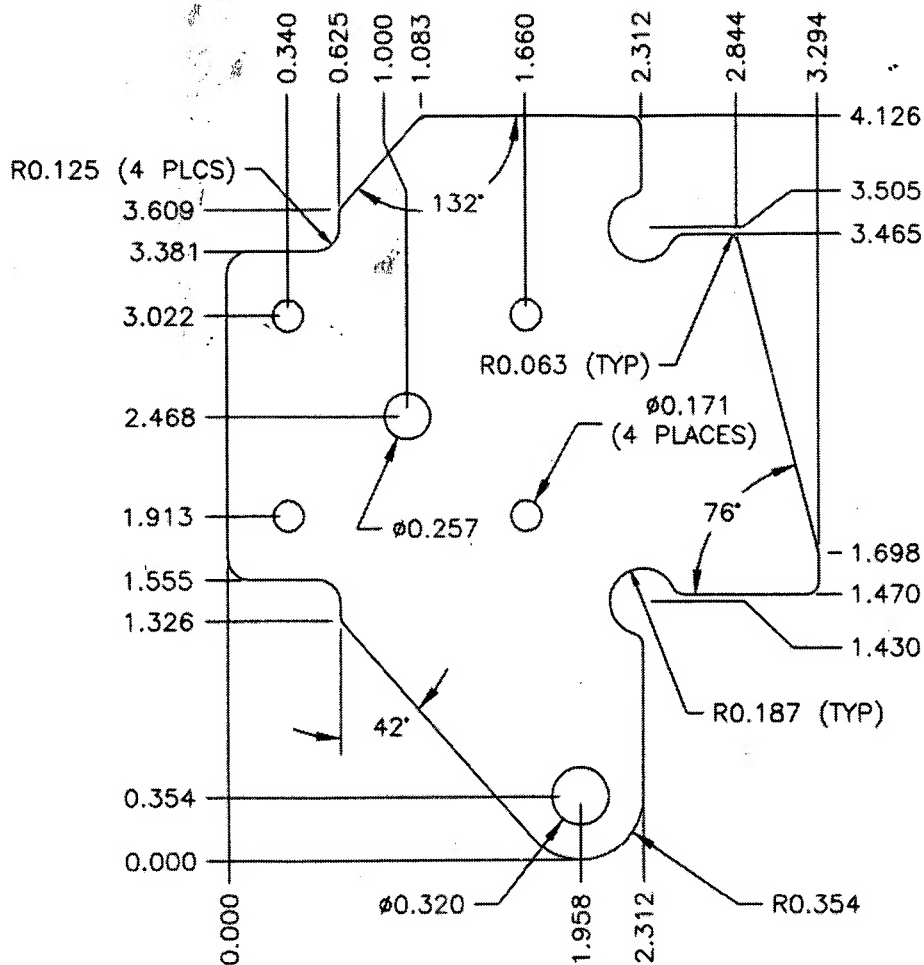
NOTE: Date & initial all entries



DESIGN BW	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED RJA	APPROVED [Signature]	DRAWING NO. D2144	REV. D SHEET 2 OF 2
DATE 98.10.08	TITLE HINGE BRACKET		SCALE 1:1

RELEASED
98.10.15 KB

84070



D2144 FLAT PATTERN

MATERIAL: AISI 304/316-2B SS, 0.063 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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